

Work Order ID 55710

January 28, 2010 10:53:08 AM



Page 1

Item ID: D3954-7

Revision ID:

Item Name: Ratchet Lug

Start Date: 1/29/2010 Start Qty: 6.00

Required Date: 2/15/2010 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Approvals: Process Plan: mf Date: 10-1-28 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3954	B
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100



Mill Conv

Conventional Milling Machine

Memo
mill to size

0.00

0.00

110



Waterjet

FLOW CNC Waterjet

Memo
1-Cut as per Dwg D3954
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

0.00

0.00

MAT NOT PULLED

IB 10-1-28

⑦

IB 10-1-28

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00							
125 Mill Conv Conventional Milling Machine	Memo mill as per Dwg D3954	0.00 0.00							
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							

13 ~~10-1-28~~
13 10-1-28

SL 10/01/29
SL 10/01/29
SL 10/01/29
88 10/01/29

10-03-10
22

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 	Spray Paint Spray Painting	0.00							
	<i>145 Powdercoat</i>								
	<i>M11354X</i>								
	<i>QC3</i>								
	<i>QC14- Inspect Spray Paint</i>								
150 	QC	0.00							
	Quality Control								
	<i>QC3</i>								
	<i>QC14- Inspect Spray Paint</i>								
	<i>QC</i>								
	<i>Quality Control</i>								
160 	Packaging	0.00							
	Packaging								
	<i>Identify as per dwg & Stock Location: ST x1</i>								
	<i>u/o 55706 x6</i>								

START: 3:15pm 24 10/04/09
Temp: 370°F
FIN: 3:45pm

15K 10-02-10

(7)

10-3-15

(x6)

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Item ID: D3954-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Ratchet Lug

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Cust Item ID:

Required Date: 2/15/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/10 HJ

P10-3-44
(7)

Picklist Print

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Page 1

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Parent Item: D3954-7

Parent Item Name: Ratchet Lug

Start Date: 1/29/2010

Required Date: 2/15/2010

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M1010B1.000X02.000 Purchased No



1010-1025 Steel Bar 1.00 x 2.00



10-1-28

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

107436

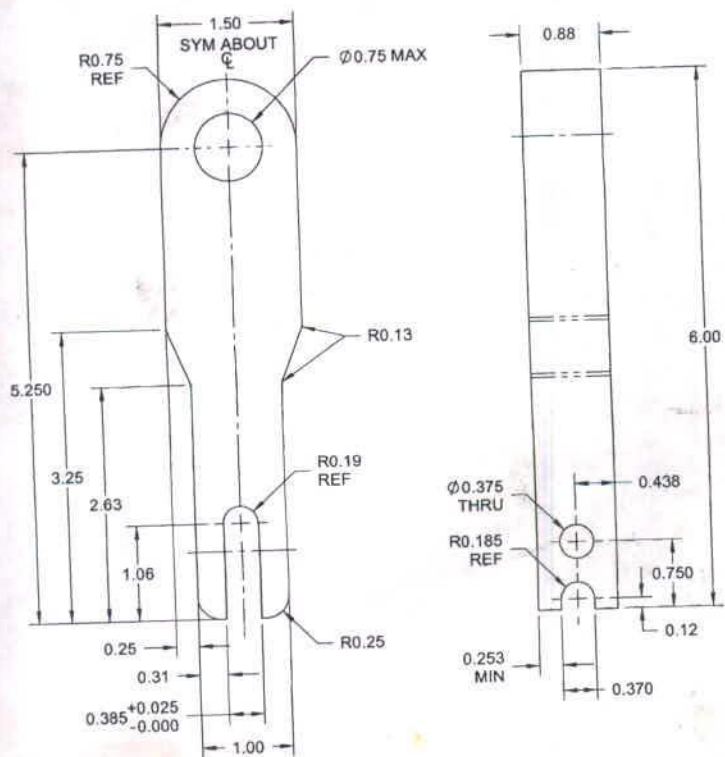
110368

9.06

9.06

7

110368



D3954-5 CHAIN LUG

NOTES:

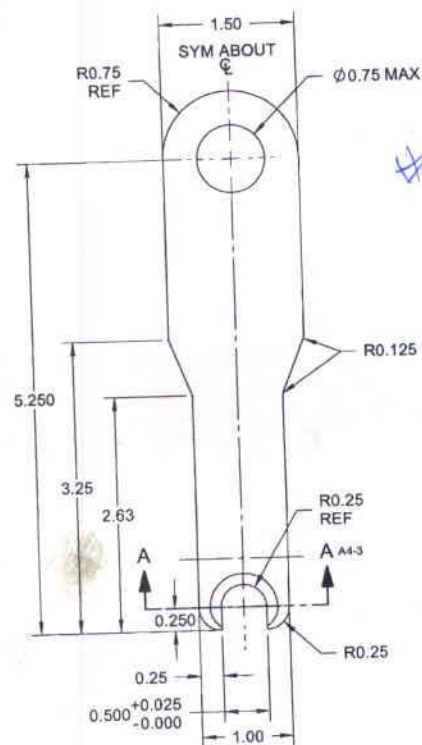
1) MATERIAL: -5/-7: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

9: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

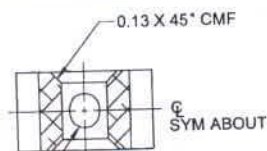
ALTERNATE MATERIAL:
-5/-7: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

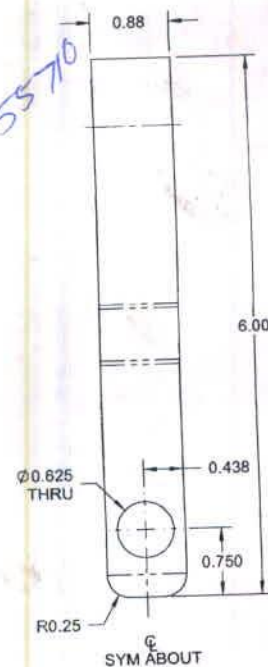
- 2) FINISH -7 ONLY: SPRAY PAINT YELLOW WITH BERTRAND CG1031B PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -5/-7: 1.56 lbs EACH
-9: 0.05 lbs



D3954-7 RATCHET LUG



SECTION A-A C3-3



D3954-9 GWT CHAIN PIN

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT NTS	
DATE	09.10.15	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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2009-10-19

